



Dart Aerospace Ltd.
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K6A 1K7
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D3913-041
Job Sheet 185680



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18		0.00	0.00	Start Up Large Fab-5		20/11/18
100	Large Fab	1 pcs	11/23/18		0.00	10.00	Large Fab 1		26/11/18
110	QC	1 pcs	11/23/18		0.00	0.00	QC9		
120	QC	1 pcs	11/23/18		0.00	0.00	QC5		
125	HandFinish	1 pcs	11/23/18		0.00	0.29	HandFinish2		18-11-27
130	Powdercoat	1 pcs	11/23/18		0.00	0.93	Powdercoat2		18-11-27
135	Packaging	1 pcs	11/23/18		0.00	0.00	Packaging1		18-11-27
140	QC	1 pcs	11/23/18		0.00	0.00	QC3		18-11-27
150	HandFinish	1 pcs	11/23/18		0.00	0.50	HandFinish4		18-11-27
160	QC	1 pcs	11/23/18		0.00	0.00	QC5		18-11-27
170	Packaging	1 pcs	11/23/18		0.00	0.00	Packaging3-2		NOV 27 2018
180	QC21-SA	1 Ea	11/23/18		0.00	0.00	QC21		NOV 27 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138951 START: 11:20 OJT: 345° FINISH: 11:35.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	512888
D3913-1 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5129582
D3913-15 ✓	Wide Handle Plate	1 Ea (1 ea) ✓	90-Start up Operation	5108592
D3913-3 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5112730
D3913-7 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5115925
D3913-9 ✓	Hinge Rib	1 Ea (1 ea) ✓	90-Start up Operation	5116572
D3916-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	5122708
D3916-5 ✓	Light Rib	3 Ea (3 ea) ✓	90-Start up Operation	5128079
D4016-1 ✓	Hinge Half, Base	3 Ea (3 ea) ✓	90-Start up Operation	5112356
D4017-7 ✓	Rib	3 Ea (3 ea) ✓	90-Start up Operation	1X5 110037/2X125006
D4017-9 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5115755

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

8109707
 5115200
 5125274
 5125300
 3114035
 5093684
 5106952
 F86435
 5076007
 5094592
 5109991
 5108627

Job Allocations

066716

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	42	0
	D3913-1	1	1	0
	D3913-15	1	16	0
	D3913-3	1	2	0
	D3913-7	2	16	0
	D3913-9	1	8	0
	D3916-041	2	8	0
	D3916-5	3	11	0
	D4016-1	3	214	0
	D4017-7	3	10	0
	D4017-9	2	16	0
	D4020-11	2	21	0
	D4021-1	3	25	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	6	0
	M304EX0.75-16F	33	1,189	0
	AN3-10A	6	137	0
	D2931	2	928	0
	D4021-5	2	37	0
150-HandFinish	MS20600-AD4W3	2	319	0
	MS21042L3	6	2,363	0
	NAS1149F0332P	12	2,093	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 11:38 AM Dart.lajeunesse.marie

add
 D3193-15 5108592 x 1
 D3913-3 5112730 x 1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation			Disposition																		
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 692-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 11/21/18 Container No: S129834 Part: D3913-041 Job No: 185680 Serial No/Batch: S129834 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
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